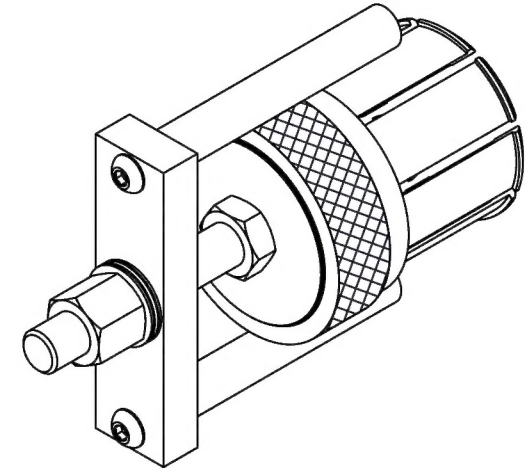
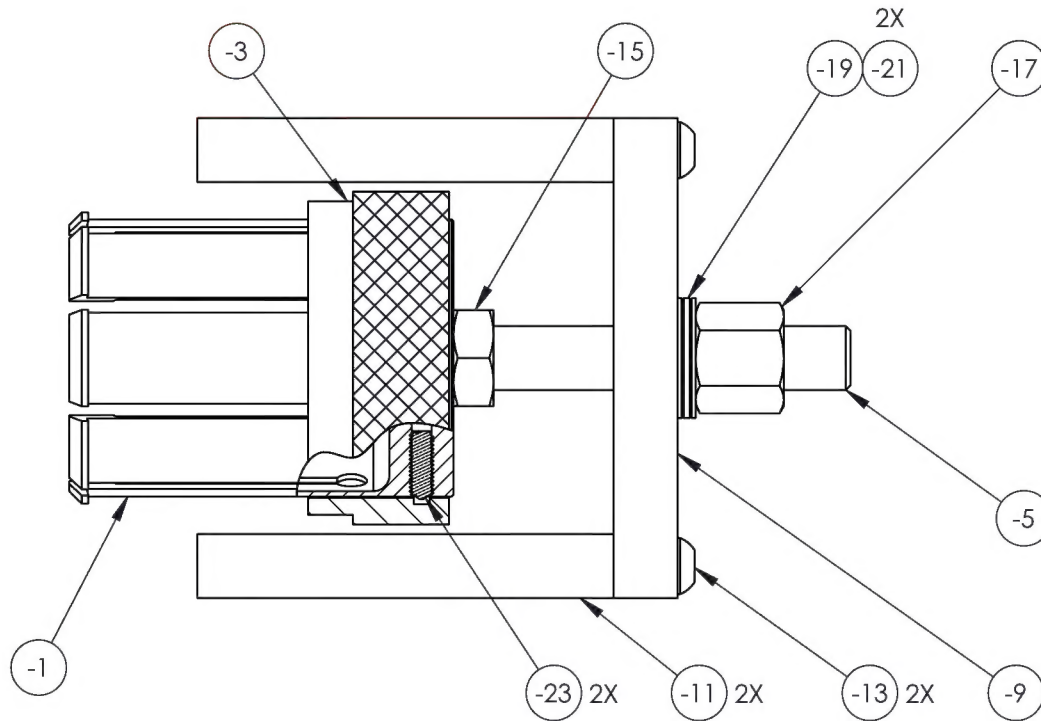


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TEO ATTACHED

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 PULLER SLOT HOLES INCREASED TO Ø1/4 & WALL THINNED FOR FLEXABILITY, -3 RING SHORTENED & GROVE MOVED TO ALLOW -1 PULLER TEETH TO FULLY EXPAND, -7 ILLUMINATED, -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003		
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE. RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG, AND COMBINED TWO FILES.	11/20/2007	WP	RW
3		CH'D -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE
4	15-0472	-9 CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG



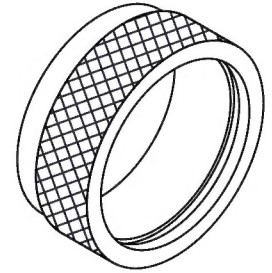
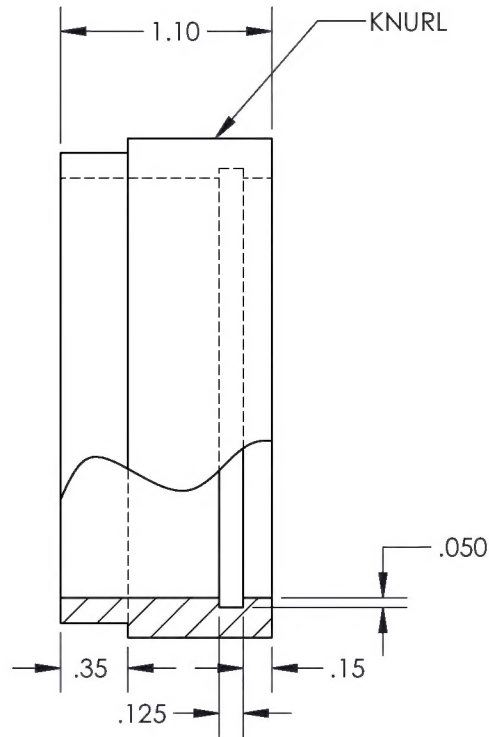
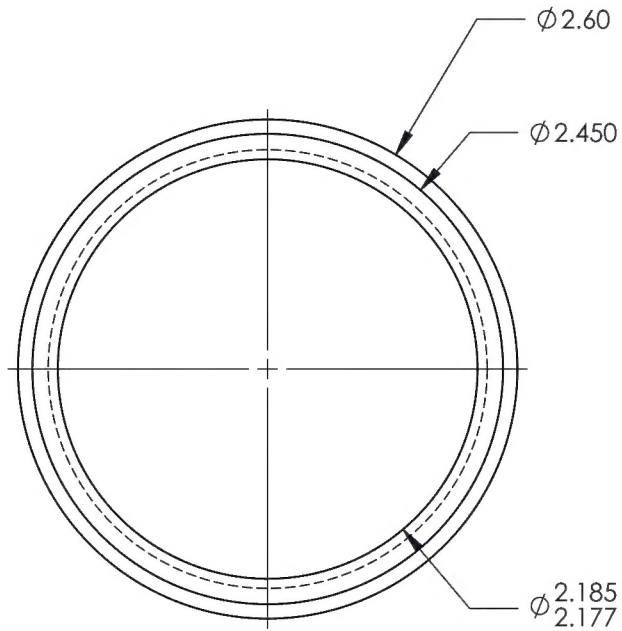
NOTE:
1. USED ON BELL MODELS 206A, B, L1-L4.
SEAL #406-340-104-101

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PULLER	H13		2
			-3	1	RING	DOM		3
		B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMaster-CARR # 98750A483) MODIFIED	4
			-9	1	CROSS BAR	1018/1020 CR		5
			-11	2	UPRIGHT	1018/1020 CR		6
		B/O	-13	2	BTN-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMaster-CARR # 91255A542)	1
		B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMaster-CARR # 94846A525)	1
		B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMaster-CARR # 90565A330)	1
		B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
		B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
		B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMaster-CARR # 3408A94)	1

DART AEROSPACE			
TITLE ENGINE/GEARBOX SEAL PULLER			
DWG NO. RBT18560			REV 4
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ±.5°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125°	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 2:3		3. INTERPRET DIM AND TOL PER	
DATE 5/2/2002		ASME Y14.5M-2009	
SHEET 1 OF 6		USED ON MODEL	
		SEE NOTE 1	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

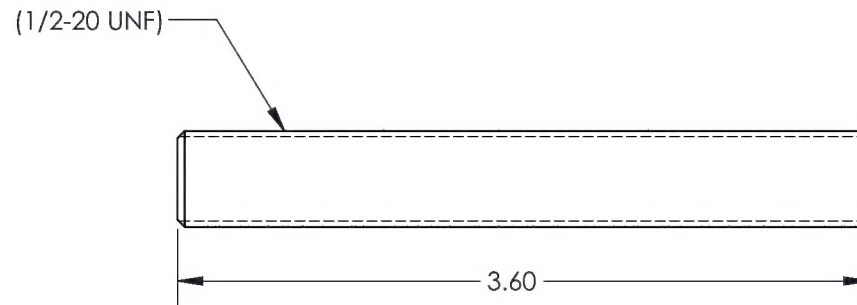
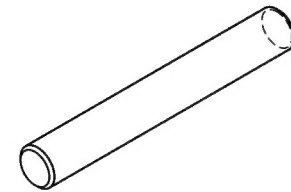


(-3)
RING

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-3	REV 4
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED: WEIL	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	SEE SHT 1
SCALE 1:1	DATE 5/2/2002
	SHEET 3 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



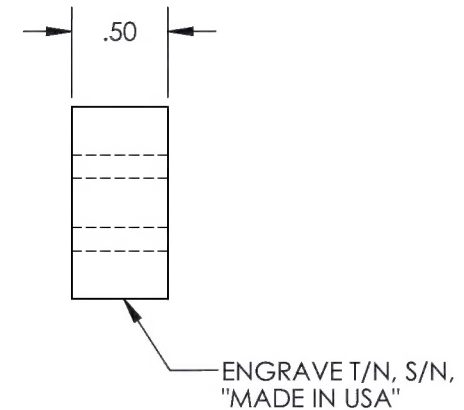
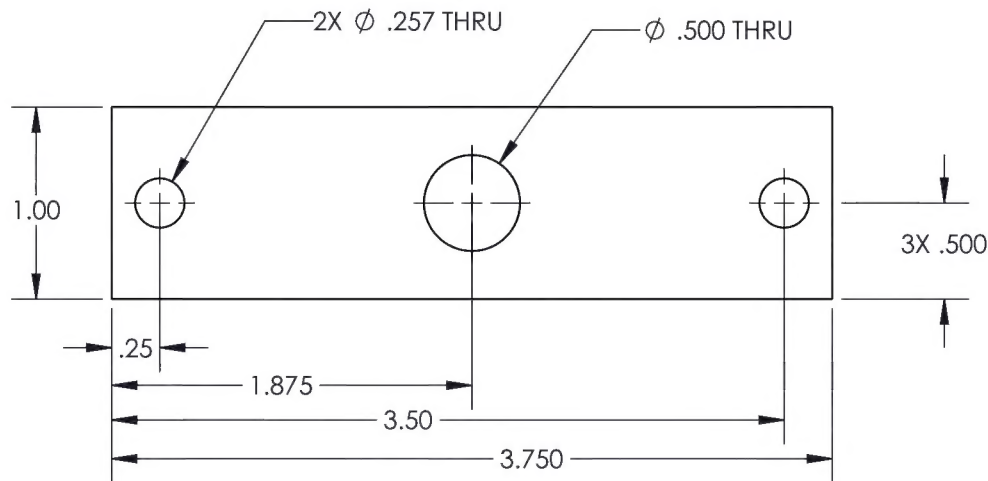
(5)

SCREW

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-5	REV 4
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED: WEIL	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 5/2/2002	USED ON MODEL
SHEET 4 OF 6	SEE SHT 1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D -9 HOLE FROM Ø.250 TO Ø.257 PER S.E.	12/29/2011	RJC	SE
4	15-0472	CH'D -9 ENGRAVE NOTE TO: T/N, S/N, "MADE IN USA"	1/5/2016	SM	

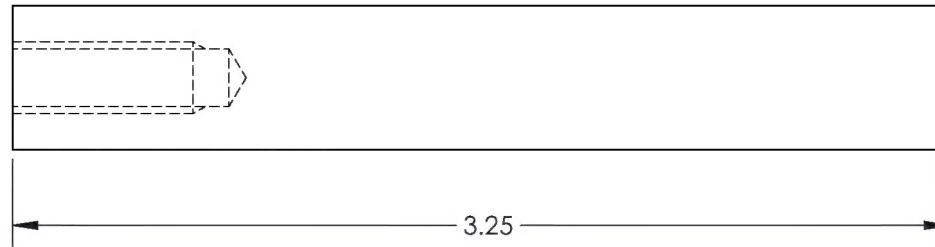
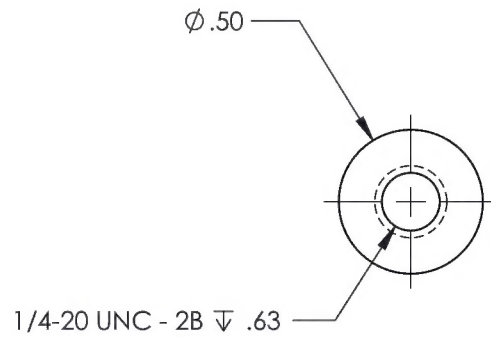
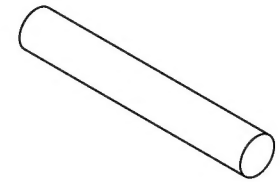


⑨
CROSS BAR

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-9	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED: WEIL	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 5/2/2002	USED ON MODEL
SHEET 5 OF 6	SEE SHT 1

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-11)

UPRIGHT

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-11	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: COLE	.X \pm .1 SURFACES = 125°
CHECKED:	1. BREAK ALL SHARP EDGES
OPPS APPR:	.015 x 45° OR .015R
QA APPR:	2. DIMENSIONAL LIMITS APPLY
APPROVED: WEIL	AFTER PLATING
SCALE 3:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 5/2/2002	USED ON MODEL
SHEET 6 OF 6	SEE SHT 1



ENGINEERING ORDER # TEO17-643

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBT18560

REV: 4

EFF.: NEXT ORDER

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DATE 17.09.07

TITLE: ENGINE/GEARBOX SEAL PULLER

APPROVED:

MFG. APPR.:

CHECKED:

DRAWN: VM 09/25/2017

TRANSACTION CODE (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MATERIAL NEED UPDATED

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WAS : PART# RBT18560-3 Rev 4 MATERIAL : DOM
IS : PART# RBT18560-3 Rev 4 MATERIAL : A513 TUBING AS PER MT-A513-T

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM